

Work Order ID 118449

Tuesday, September 09, 2014 11:23:46 AM

118449

Page 1

Item ID: D206-642-511 REPAIR Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube LH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible
 Start Date: 9/9/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/10/2014 Req'd Qty: 1.00 ***1*** Customer: CEDWA01
 Reference: RMA RA111862

Approvals: Process Plan: MF Date: 14-9-9 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	Q								

100

0.00

100

QC

Quality Control

Memo

INSPECT RA 111862 D206-642-511 X 1 B112854

REWORK PER RS 1020

0.00

(1541
112940)

110

0.00

110

HandFinish

Hand Finishing

Memo

SEE RS1020

0.00

1x f ll 11/09/12

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Quality Control

Memo

0.00

1 DAS 38 9.88 14-9-15

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging	ID AND STOCK UNDER NEW BATCH NUMBER								
	NO PAPERWORK NEEDED								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MF
14-9-16

Picklist Print

Page 1

Tuesday, September 09, 2014 11:23:39 AM

Work Order ID: 118449

118449

Parent Item: D206-642-511 REPAIR

D206-642-511 RFPAIR

Parent Item Name: Skidtube LH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 9/9/2014

Required Date: 9/10/2014

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D206-642-511 REPAIR

Manufactured No

Each 1.0000

1

D206-642-511 RFPAIR

1 X 112821 MF 14-9-9

Skidtube LH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

D2649

Manufactured No

Each 429.0000

12

D2649

BEV-09-09

Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

203

123099

203

LG001

226

107906

3

112728

6

113811

2

120508

209

90497

6

D3275-1

Manufactured No

Each 235.0000

12

D3275-1

BEV-09-09

Crossbolt Spacer

Location

Loc Qty

Loc Code

LG001

235

113246

1

113851

62

114877

74

121868

36

121974

62

RA 111862

Received @ Dart August 2nd, 2014
Inspected @ Dart August 4th, 2014

CUSTOMER: BELL HELICOPTERSTEXTRON INC
CUSTOMER CONTACT: JASON JENKINS
SHIPPED FROM: PINEY FLATS, TN USA

Instructions for RA 111862

- **D206-642-511 B112854 CHG 005**
 - Preform reworking as per **RS1020**
 - Tube to stay at CHG005
- **D206-642-512 B112860 CHG 005**
 - Preform reworking as per **RS1021**
 - Tube to stay at CHG005
- No saddles returned with tube
- All original hard ware will be re assembled as per IIN

Time Estimate = 4 DAYS

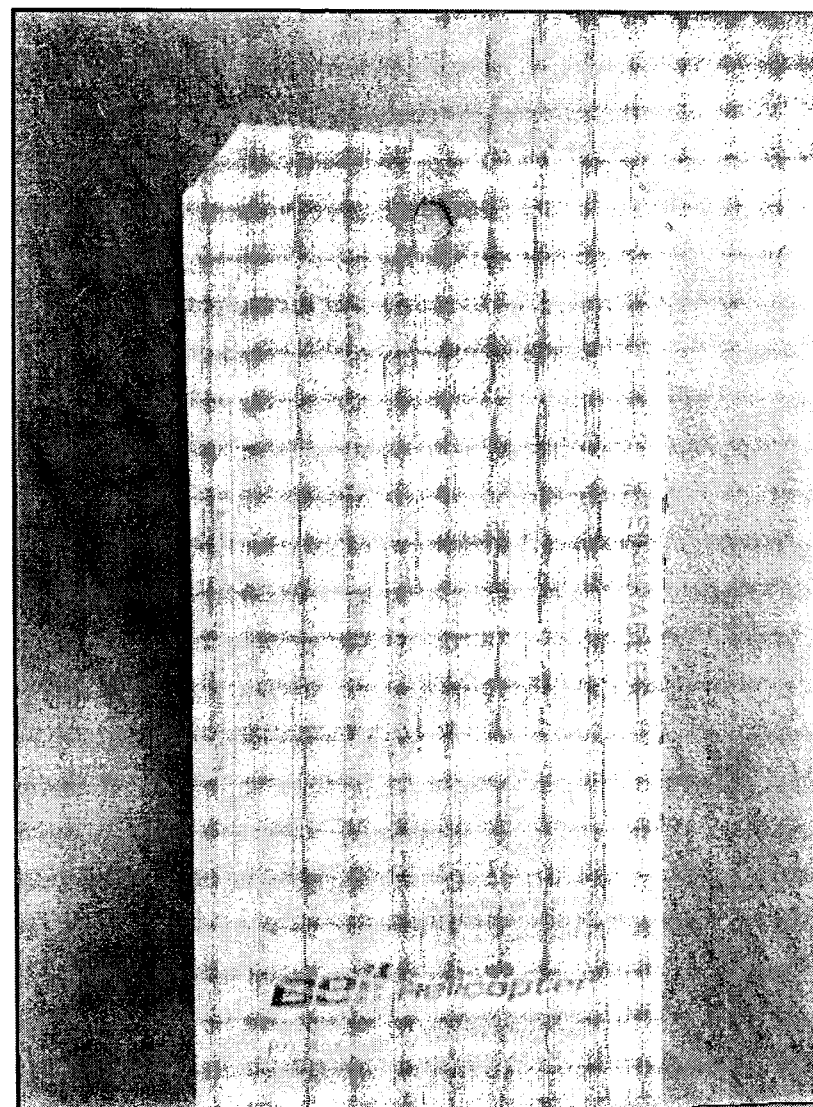
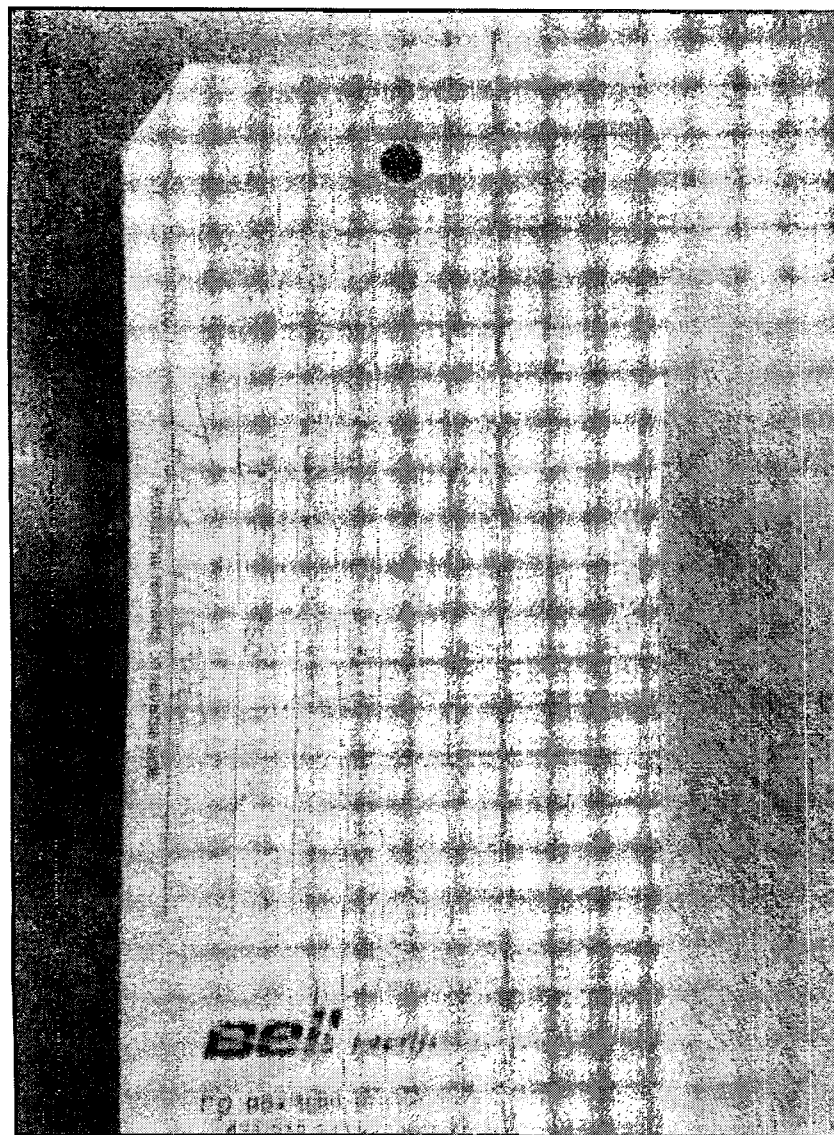
Departments Required: finishing, landing gear (skid tubes), packaging & QC

Pictures Attached = NO

Current CHG # 006 but tube will stay @ CHG005

QTY INSPECTED = x1 D206-642-511 B112854 CHG005
x1 D206-642-512 B112860 CHG005

**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**



DART AEROSPACE LTD	Work Order:	118449
Description: RA 111862 D206-642-511		
Drawing: D3274-041	Repair Scheme:	RS1020
Part No: D206-642-541	Page:	1 of 2
Batch No: B112854	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	QC	INSPECT RA 111825 D206-642-511 B112854 <ul style="list-style-type: none"> Removed of A/C 407GX S/N54455 Original removal tag attached to work order No saddles returned with skid tubes 			
2	FINISHING / LANDING GEAR (SKID TUBES)	DISASSEMBLE TUBE & ID WITH ORGINIAL BATCH #'S AND D206-642-511 B112854 <ul style="list-style-type: none"> Remove D parts D3407-043 B103044 D3413-1 B107984 D2646 B110816 D3414-041 B108074 or B109539 D3537-1 B112567 D3537-3 B111825 D3535-15 B110201 D3536-15 B110698 D3535-23 B110063 D3536-23 B112179 D3535-39 B101535 D3536-39 B108021 D3535-35 B110763 D3536-35 B113306 Discard all original hard ware and to be replaced with new. TAKE SPECIAL CARE NOT TO DAMAGE THE GASKETS			
3	FINISHING	Strip entire tube of all paint & primer as per QSI005			
4	LANDING GEAR (SKID TUBES)	Drill out and remove all x-bolt spacers ^{8TH, 11TH, 12TH} D2649 & D3257-1 ³²⁷⁵⁻¹ Ensure that all foreign objects have been removed from inside the skid tube	BE	14-09-09	1
5	LANDING GEAR (SKID TUBES)	Buff area around x-bolt spacers to be free of any alodine to avoid contamination Weld as per dwg & QSI004 new x-bolt spacers D2649 B <u>120508</u> qty x <u>1</u> ⁷⁵⁻¹ D3257-1 B <u>121868</u> qty x <u>3</u> AR <u>m/25127</u>	BE	14-09-09	1
6	LANDING GEAR (SKID TUBES)	A. Buff welds B. Counter bore ϕ .375" holes as per dwg ϕ .313"x0.75" DEEP C. Debur		14-9-9	1
7	QC	Inspect QC 5 + Q10 Ensure that SADDLES and GHW fit			
8	FINISHING	Re alodine as per QSI005		14-9-10	1
9	FINISHING	Prime as per dwg & QSI005 4.2 Primer PRC Desoto 515x349 B <u>129568</u> & Exp <u>2015</u>	DAS 41 9-89	14-9-11	1

DART AEROSPACE LTD	Work Order:	
Description: RA 111862 D206-642-511		
Drawing: D3274-041	Repair Scheme:	RS1020
Part No: D206-642-541	Page:	2 of 2
Batch No: B112854	Qty:	1

10	FINISHING	Paint white as per dwg & QSI005 4.2 Paint B 129977 & Exp 2015	DAS 41 9-89	14-9-11	1
11	QC	Inspect QC14	DAS 15 9-89	14/09/12	x1
12	FINISHING	Re assemble all original D parts with all new hard ware <ul style="list-style-type: none"> • AN4C5A BOLT M 11127 410 x1 • AN960C416 WASHER M 11127 306 x1 • AN3C4A BOLTS M 11129 520 x80 • AN960C10L WASHER M 11127 410 x80 • NAS1515H3L WASHER M 11128 976 x2 • AN3C37 A BOLT M _____ x4 • D2652 BUSHINGS B _____ x8 • MS21043-3 NUTS M _____ x4 • NAS1149C0332R WASHERS M _____ x4 • D3456-1 WASHER B _____ x1 • D3457-1 WASHER B _____ x2 • MS21043-4 NUT B _____ x1 <p>SIKAFLEX B# 11129 817 EXP 14/11</p>	DAS 38 9-89	14/01/12	x1
13	QC	Inspect QC 5 Final assembly Ensure that all bolts are at correct torque Ensure that all foreign objects have been removed from inside the skid tube	DAS 38 9-89	14-9-15	
14	STORES / SHIPPING	Identify & Stock			
15	QC	QC21			

Rev	Date	Change Description	Prepared	Checked	Approved
A	13.11.26	New Issue	ED		UP

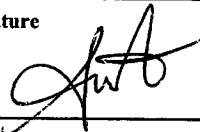
U:\Admin\Forms\Repairschemb1A.doc

Rev. A

Part No: ~~D3537-1~~ ~~D3537-3~~ ~~D3535-15~~ ~~D3536-15~~ ~~D3535-23~~ ~~D3536-23~~ ~~D3535-39~~ ~~D3536-39~~ ~~D3535-35~~

Batch No: ~~B120648~~ ~~B145122~~ ~~B113123~~ ~~B113051~~ ~~B114930~~ ~~B114897~~ ~~B110704~~ ~~B113118~~ ~~B115080~~

Quantity
 X9 (D3536-35)
 X1 B115037 (x1)
 X1
 X1 (D3413-1)
 X1 (B12025) (x1)
 X1 (D2646)
 X1 B119656 x1)
 X1
 X1

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE Form One			3. Form Tracking Number: PS-2014-09-16-2	
4. Organizations Name and Address: Dart Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario, K6A 1K7, CANADA Tel: 1 (613) 632-5200 Fax: 1 (613) 632-5246 www.dartaero.com					5. Work Order/Contract/Invoice PO145700EA	
6. Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial/Batch Number:	11. Status/Work:	
1	Float Skid Tube	D206-642-511	1	B118449	Repaired	
12. Remarks: Part returned from customer for repair according to Dart Engineering repair Scheme RS1020 carried out on work order B118450. Part was removed from Bell Registration Aircraft 407GX at 9.0 hour on work order C21045EA. Original part Batch # B118450. Returned to Dart on Return Authorization Form RA#111862.						
13a. Certifies that the items identified above were manufactured in conformity to: <input type="checkbox"/> Approved design data and are in a condition for safe operation. <input type="checkbox"/> Non-approved design data specified in Block 12.			14a. <input checked="" type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulations specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12, has been performed in compliance with the <i>Canadian Aviation Regulations</i> .			
13b. Signature		13c. Approval Organization Number		14b. Signature  DAS 29 9-89		14c. Approved Organization Number 9-89
13d. Name		13e. Date (dd/mm/yyyy):		14d. Name Patrick Smith		14e. Date (dd/mm/yyyy): 16/Sep/2014
30 Dec 2008(Previously form 24-0078)						
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than the authority specified in Block 1, must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements 13a or 14a do not constitute installation certification. In all cases, the aircraft technical record must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

REPAIRABLE

Part Name FLOAT SKIDTUBE LH

Part # D206-642-511 S/N B112854

Owner BHT Date 8-6-14

Type A/C 407GX TT 9.0 S/N 54455

W.O.# C21045EA DMR C21045EA/8

Part ① TSO UKN

Technician TRACY MEADER

Additional remarks on reverse side.

FAA Certificate #FKFR930D
EASA Repair Station 145.5066
Form EA-10060-01 04/08

Be!! Helicopter

A Textron Company
P.O. Box 3689, Bristol, TN 37625-3689
423-538-5111 Fax 423-538-8469

Discrepancy:

Holes Drilled Improperly THROUGH.

SKID TUBE